

# Work Order ID 86698

**\*86698\***

Page 1

July-06-12 11:36:09 AM

Item ID: D3294-1

Revision ID:

Item Name: Bracket

Start Date: 7/06/12

Start Qty: 6.00

**\*6\***

Required Date: 8/03/12

Req'd Qty: 6.00

**\*6\***

Reference:

Approvals:

Process Plan: 10

Date: 12-07-6

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3294	Rev C

100 0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

2004.080

Memo

1-Cut as per Dwg D3294

CUt File D3294-3

Dwg Rev: C

Prog Rev: C

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

6 0 Jm 12-7-23

C 0 Jm 12-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86698

**\*86698\***

Page 2

July-06-12 11:36:09 AM

Item ID: D3294-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 7/06/12

Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

*SMB*  
*12-7-23*

*(DAS 16 2-23) 12/19/23*

*6*

**\*120\***

QC

Memo

0.00

Quality Control

130

0.00

**\*130\***

Brake NC

Memo

0.00

1-Deburr if necessary  
2-Bend as per Dwg D3294  
(Ensure angle is correct)

*6*

*SB*  
*12/08/27*

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

*(DAS 16 2-23) 12/08/27*

*(76)*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 86698

**\*86698\***

Page 3

July-06-12 11:36:09 AM

Item ID: D3294-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 7/06/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 8/03/12 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00	Smb	12-8-28	676 12-8-28				
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170		0.00							
<b>*170*</b>									
Small Fab	Memo	0.00							
Small Fab	1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294								

6x f JV 11/08/28  
6x [Signature] 12/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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\*86698\*

Page 4

July-06-12 11:36:09 AM

Item ID: D3294-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 7/06/12

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Memo

0.00

Quality Control

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

\*190\*

Powdercoat

Powder Coating

Memo

Start Time:

Oven Temperature:

Finish Time:

0.00

200

QC3- Inspect Part Finish

0.00

\*200\*

QC

Memo

0.00

Quality Control

W121279

DAS 16 12/08/29

66

6X

M/L 12/08/29

6

12/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*86698\*

Page 5

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 7/06/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: 212

0.00

\*210\*

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

ML5 12108130

ME 12-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 8626
<b>Description:</b> Bracket Assembly		<b>Part Number:</b> D3294-1
<b>Inspection Dwg:</b> D3294 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131"	✓		✓	mm01
Ø0.141	+0.005/-0.001	0.142"	✓		✓	"
6.708	+/-0.010	6.710"	✓		✓	"
1.118	+/-0.010	1.119"	✓		✓	"
5.590	+/-0.010	5.591"	✓		✓	"
1.118	+/-0.010	1.114"	✓		✓	"
13.563	+/-0.010	13.563"	✓		MT	HBO1
1.043	+/-0.010	1.044"	✓		✓	mm01
0.625	+/-0.010	0.627"	✓		✓	"
0.325	+/-0.010	0.321"	✓		✓	"
0.300	+/-0.010	0.299"	✓		✓	"
0.400	+/-0.010	0.402"	✓		✓	"
6.000	+/-0.010	6.001"	✓		✓	"
1.000	+/-0.010	1.002"	✓		✓	"
17.124	+/-0.010	17.124"	✓		MT	HBO1
16.13	+/-0.030	16.13"	✓		MT	"
7.27	+/-0.030	7.269"	✓		✓	mm01
11.97	+/-0.030	11.970"	✓		✓	Producer
8.37	+/-0.030	8.362"	✓		✓	mm01 Producer
20.05	+/-0.030	20.05"	✓		MT	HBO1
12.98	+/-0.030	12.98"	✓		MT	"
14.59	+/-0.030	14.59"	✓		MT	"
11.66	+/-0.030	11.655"	✓		✓	Producer
0.080	+/-0.010	0.080"	✓		✓	mm01

<b>Measured by:</b> JW	<b>Audited by:</b> SMB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-7-23	<b>Date:</b> 12-7-23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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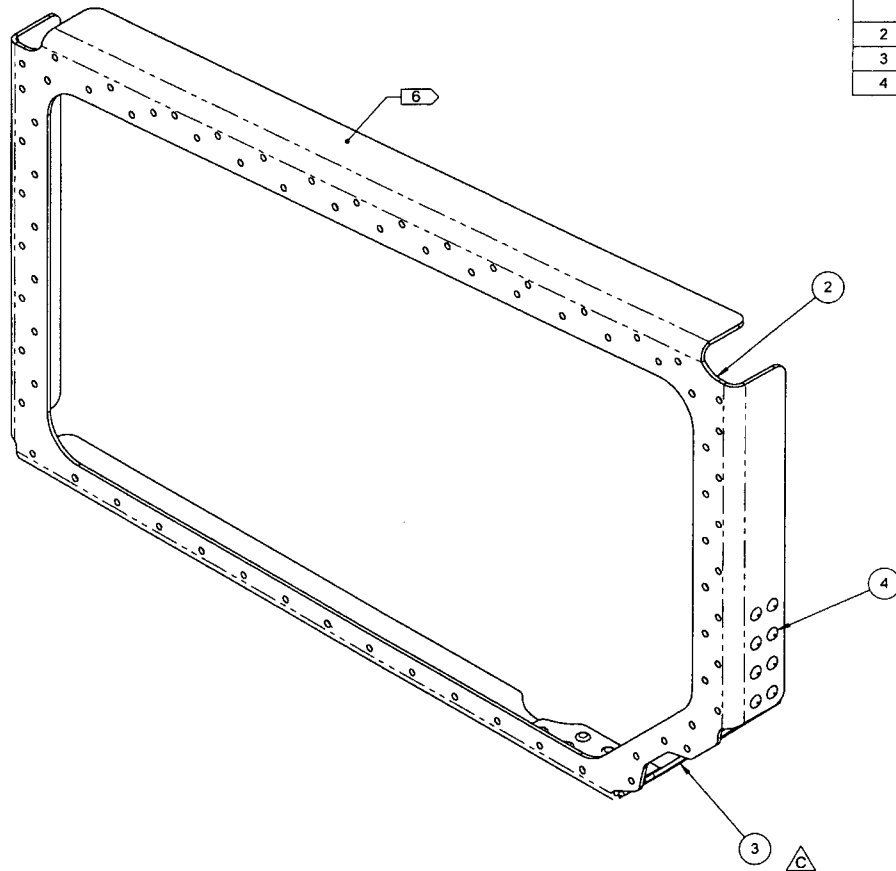
**NOTE:** Date & initial all entries

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86698

*RD 07 C*

**RELEASED**  
*09/03/24*



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

REV.	DESCRIPTION	BY	DATE
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	<i>HS</i>	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DART AEROSPACE LTD D3294 BRACKET COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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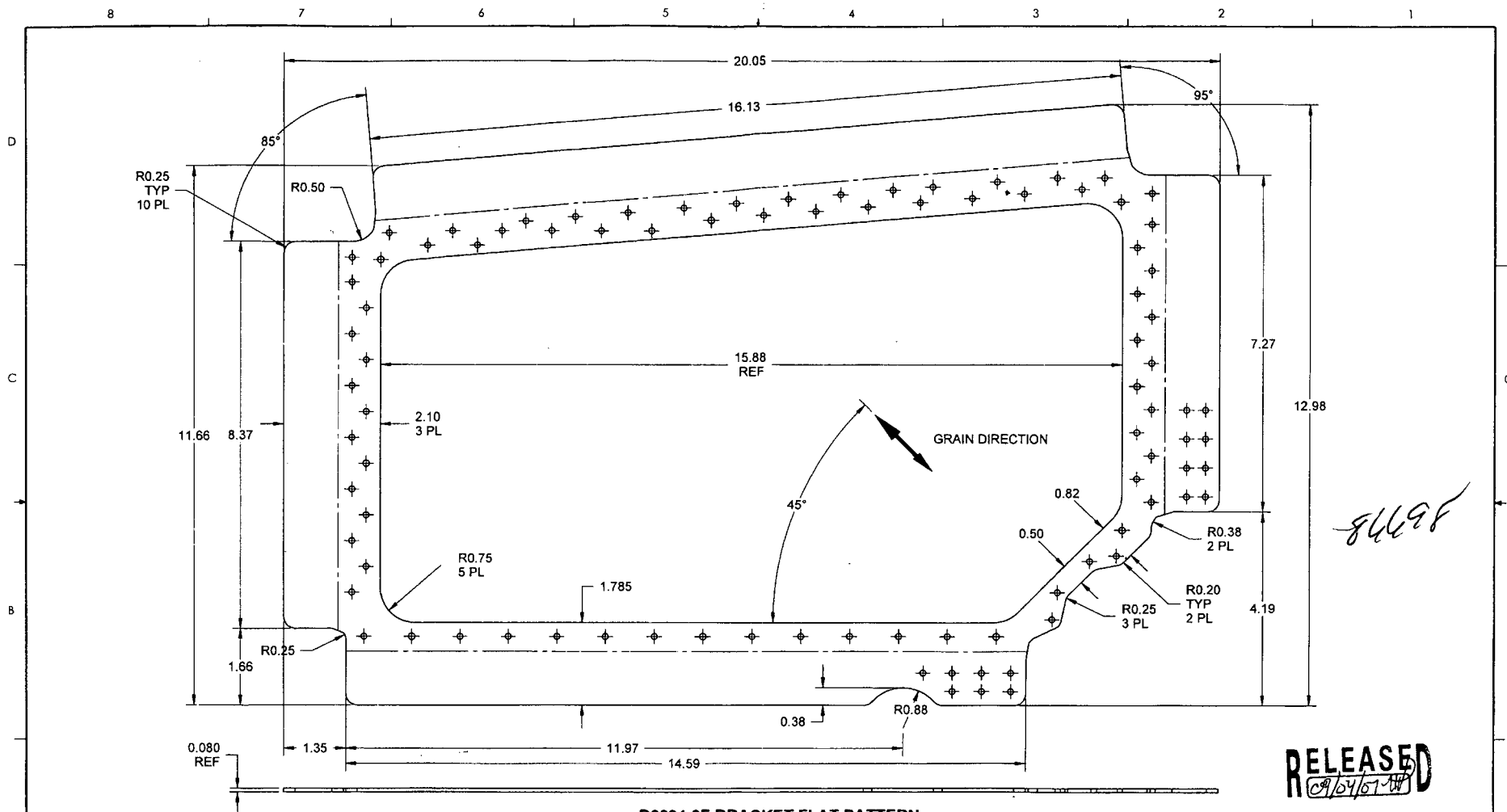
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3294-3F BRACKET FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
09/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

**D3294-3F BRACKET FLAT PATTERN**  
SUPPLEMENTAL

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3294</b>	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 6
APPROVED		<b>BRACKET</b>	SCALE
DE APPR.			NTS
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86698  
**RELEASED**  
07/01/14

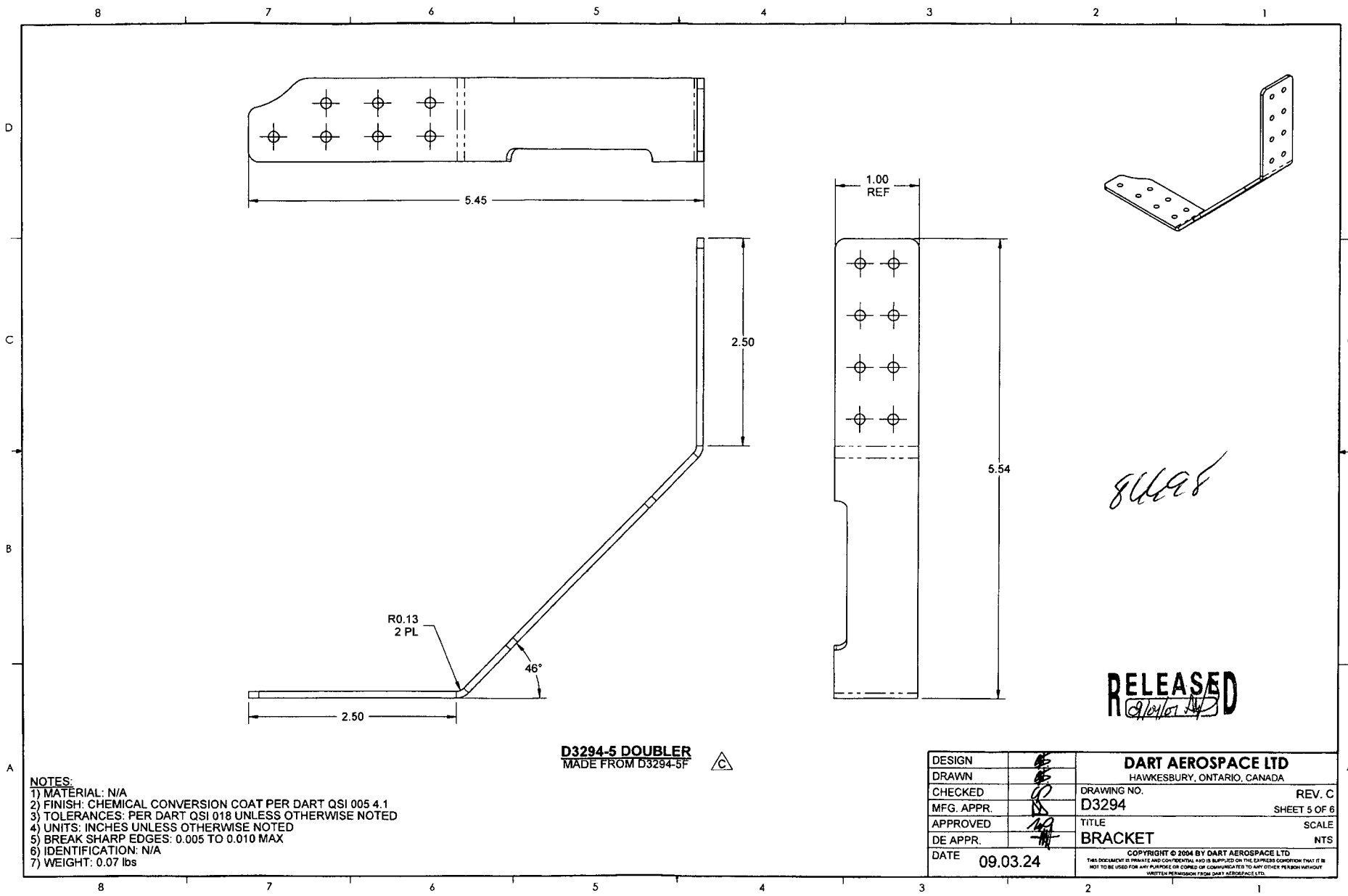
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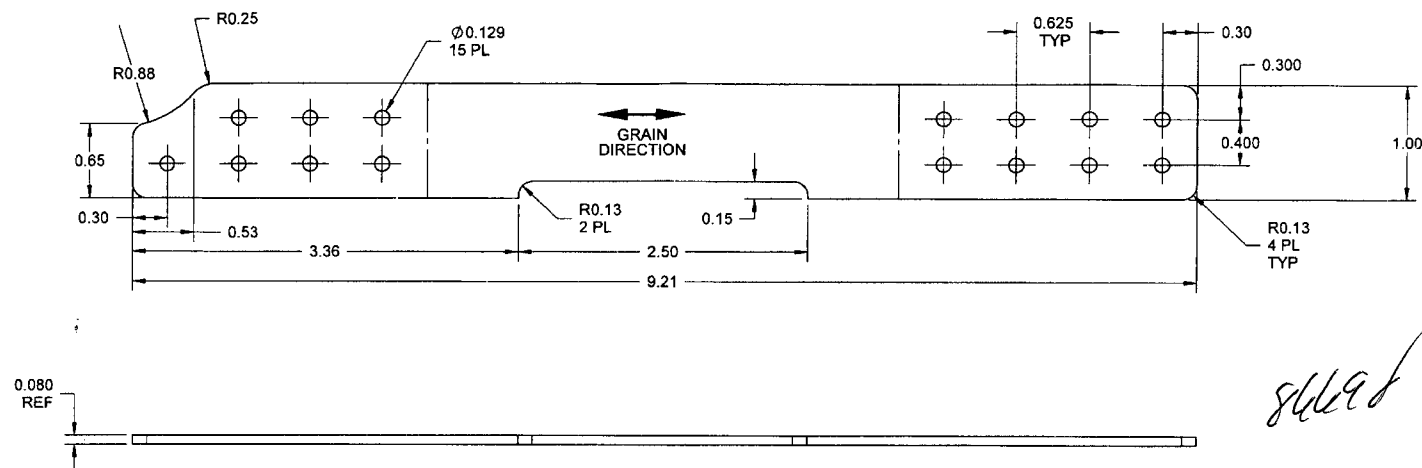
8 7 6 5 4 3 2 1

D

C

B

A




D3294-5F DOUBLER FLAT PATTERN

**RELEASED**  
09/04/07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 6 OF 6
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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